

Work Order ID 133347

Thursday, June 04, 2015 3:13:13 PM

133347

Page 1

Item ID: D4857-1

Accept

N1900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: WiperDeflector

Start Date: 6/04/15 Start Qty: 4.00

4

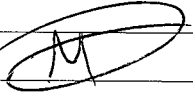
Cust Item ID:

Required Date: 6/04/15 Req'd Qty: 4.00

4

Customer:

Reference: REWORK

Approvals: Process Plan: 

Date: 15-6-4

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4857	E								

110

0.00

110

Small Fab

Memo

0.00

DAS
30
9-89

4

JUN 04 2015

Small Fab

USING 320 GRID SAND PAPER LIGHTLY BUFF DOWN BY HAND THE
BURRS. APPLY SMALL AMOUNT OF CRAZY CLUE TO SEAL ALL
EDGES.
APPLY PRIMER

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

DAS
16
9-89

15/06/04

(44)

Quality Control

130

0.00

130

HandFinish

Memo

0.00

Hand Finishing

Touch up holes with primer as per dwg
SEE NOTE 4 ON SHEET 6 FOR PRIMER
A/R PRIMER BATCH:

N/A 15-6-04

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 133347***133347***

Page 2

Item ID: D4857-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: WiperDeflector

Start Date: 6/04/15 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 6/04/15 Req'd Qty: 4.00 ***4***

Customer:

Reference: REWORK

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

QC14- Inspect Spray Paint

0.00

140

QC

Quality Control

Memo

N/A Dis 6.04

150

Identify as per dwg & Stock Location: _____ 0.00

150

Packaging

Packaging

Memo

REPACKAGE USING SAME BATCH NUMBER

0.00

RECEIVED under B# 132313

160

QC21- Final Inspection - Work Order Release 0.00

160

QC

Quality Control

Memo

0.00

N/A Dis 6.05

ML5 JUN 08 2015
JUN 01 2015

ML5 JUN 01 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

* Picklist Print

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Work Order ID: 133347

133347

Parent Item: D4857-1

D4857-1

Parent Item Name: WiperDeflector

Start Date: 6/04/15

Required Date: 6/04/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 13.10.18 DD VERIFIED BY:JLM IPP
REV:B 14.05.21 REV.PD10 DD VERF:JLM IPP REV:C
14.05.07 DWG REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4857-1

Manufactured No

Each 0.0000

D4857-1

WiperDeflector

132313

**

4
15-6-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



Non-Conformance Report

Reviewed			
DQA:		Printed on: Thursday, June 04, 2015	
Date:			
Details			
Raised Date 6/4/2015	Status Open	Owner	Number NCR15-5057
Target Date 6/16/2015	Standard	Severity MAJOR	
Process Quality Inspection		Audit	
Raised By Person Downing, Eric M	Raised Against (Department or Supplier) Manufacturing\Small Fabrication		Fault Category General\Deburring/Burrs
Details found when performing the as9102 FAIR that the D4857-1 parts have a large burr around the 0.210" holes. parts were not properly deburred			
Keywords		Product	
Document		Root Cause	
Closed By	Closed Date	Resolution	
Corrective Action			
Target Date 6/15/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			
Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Poulin, Mario	6/5/2015	
pull all parts from stock			
2	Poulin, Mario	6/5/2015	
create work order to rework parts. use a peice of 320 grit sand paper and lightly buff down by hand the burrs. apply small amount of crazy glue to seal all the edges / fibers and re apply the primer coating.restock under original batch numbers			
3	Downing, Eric M	6/12/2015	
retrain all employees (inspectors & small fab workers) the correct way of performing the de-burring of these parts. record on job training logs		W/O 133347	

Verification & Review

Target Date 6/15/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	